

slip 23/01

4

Date: Monday, 1/7/2008 11:13:37 AM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (19"X24")
Job Number : 36595	
Estimate Number : 12617	
P.O. Number : <i>N/A</i>	Part Number : D315670011
This Issue : 1/7/2008 S.O. No. : <i>N/A</i>	Drawing Number : D2432 REV F3
Prsht Rev. : <i>NC</i>	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : F3
Previous Run : 36333	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 1/23/2008 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature] 08.01.07</i>	
Comment : Est Rev:A New Issue 07-01-03 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



KS 08/01/07

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D315-670-011 CHG001

08/01/15

2.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 6.8250 sf(s)/Unit Total : 27.3000 sf(s)

blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5

Material: Black UHMW 1"

(MUHMWB10)

Batch: *M106161 x 48" long x 2 pcs.**M106717 - 12' long x 6 pc's**DTP 08/01/11*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

*DTP 08/01/11 / J.L 08/01/13*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L 08/01/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 1/7/2008 11:13:37 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 36595

Part Number: D315670011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/01/14

(4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total : 10.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050

Rubber Cushion

34227 18x

B30396 6x

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274

Radius Block

32857

2 D2432F(ref only)

Bearpaw

36595

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438

Clamp

B32016

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

B35356

CU 8/01/14 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 10 Date: 20/01/15

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 11:13:37 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 36595

Part Number: D315670011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M103691

12.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

M105906

13.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M105084

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD315-670-011

Location: A

8/1/15

500 (4x)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.01.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 36595
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2432
<b>Inspection Dwg:</b> D2432	<b>Rev:</b> F3	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.065x45°	✓			
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	.176	✓			
D	0.25 x 45°	+/-0.030	.256x45°	✓			
E	R0.250	+/-0.030	0.250	✓			
F	0.250	+/-0.010	.256	✓			
G	0.625	+/-0.030	.605	✓			
H	0.375	+/-0.010	.385	✓			
I	0.950	+0.030/0.010	.948	✓			
J	19.000	+/-0.030	19.00	✓			
K	3.14	+/-0.030	3.145	✓			
L	3.28	+/-0.030	3.280	✓			
M	Ø0.260	+0.005/-0.000	.260	✓			
N	Ø0.93	+/-0.030	.930	✓			
O	0.30	+0.030/-0.000	.310	✓			
P	23.750	+/-0.030	23.750	✓			
Q	7.375	+/-0.030	7.371	✓			
R	4.250	+/-0.010	4.250	✓			
S	2.000	+/-0.030	2.007	✓			
T	9.000	+/-0.010	9.000	✓			
U	9.000	+/-0.010	9.000	✓			
V	0.375	+/-0.010	.375	✓			

<b>Measured by:</b> J.L	<b>Audited by:</b> J.F	<b>Prototype Approval:</b> N/A
<b>Date:</b> 08/01/12	<b>Date:</b> 08/01/12	<b>Date:</b>

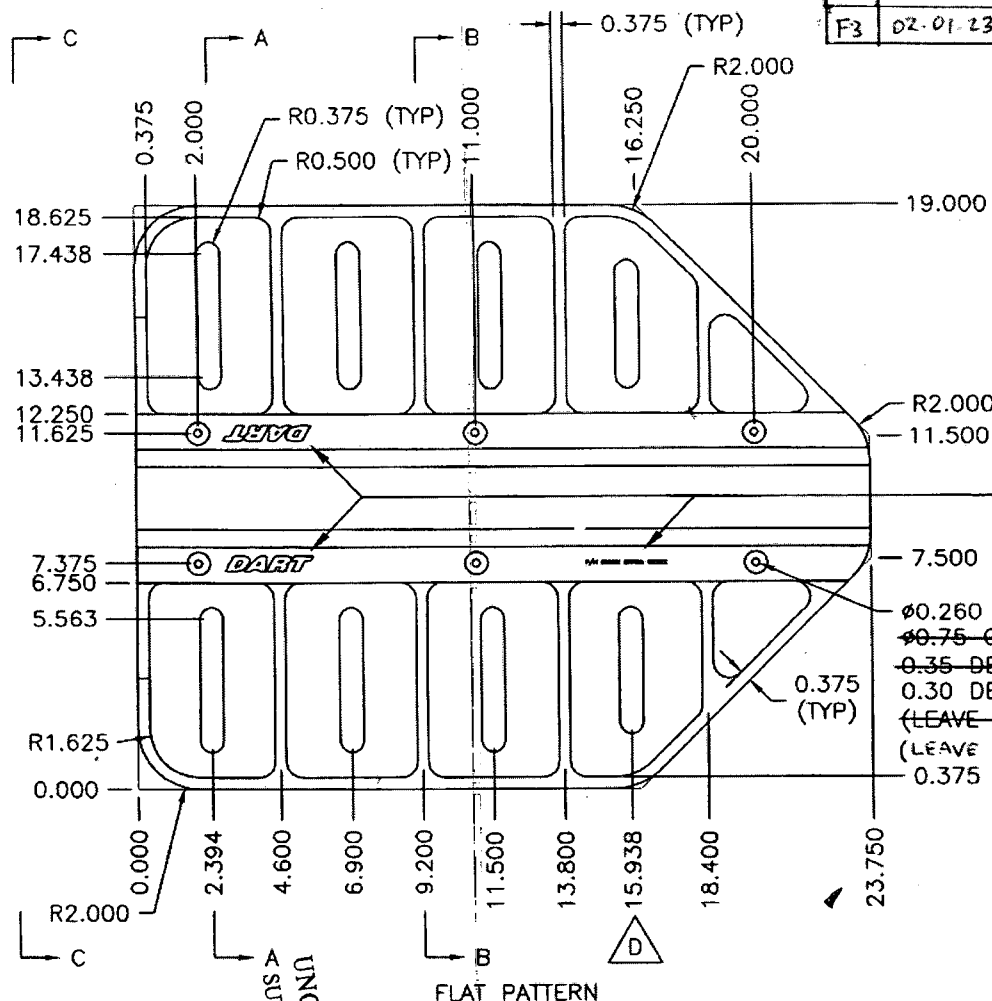
Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	JF



DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	AS	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE
		1:6

RELEASED  
48.06.17 KE

F1	99.03.03	ADD DEC 9143
F2	01.03.28	<del>Ø0.93 WAS Ø0.75</del> RF
F3	02.01.23	CLARIFY CORE DIMS RF



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

F2  
F1  
F

EFFECTIVE DEOS  
9143

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36595

D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

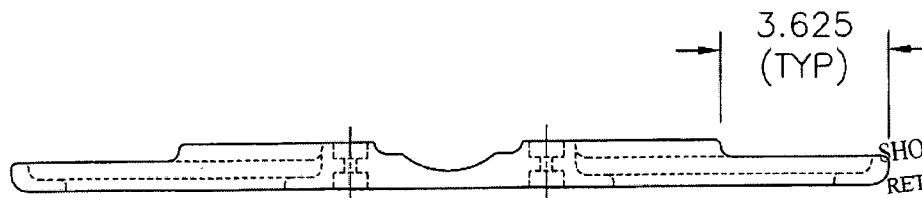
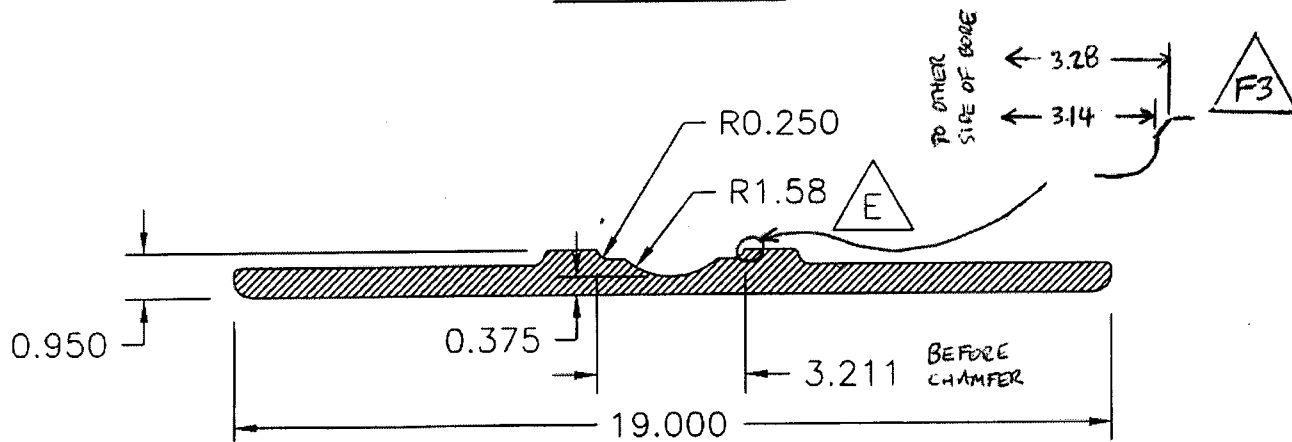
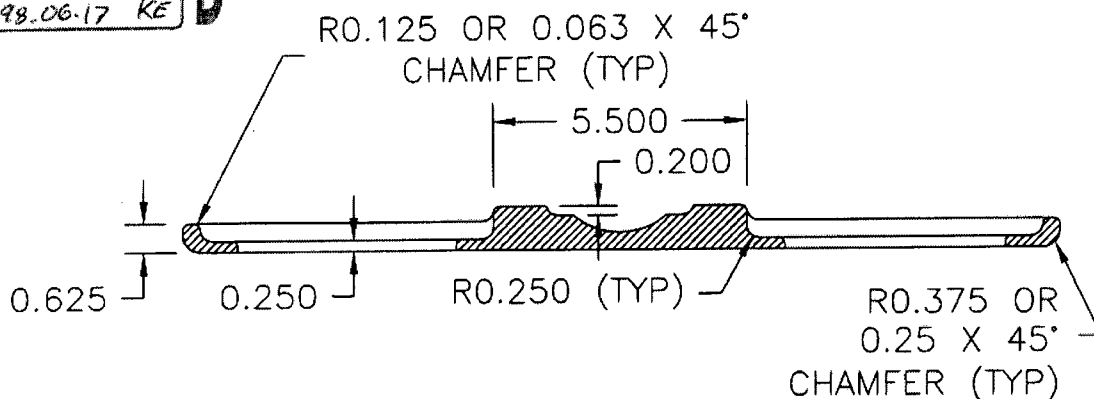
F





DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED  
98.06.17 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36595